



You imagine  
we shape it

# FORMING STATION



Initial design is made for the maximum height of the product in the market. Just by changing the inserts (H105, H75 and/or H58), i. e.  $h = 20 \sim 105$  mm will be possible. The maximum depth depends on the machine's max. forming depth.

Cooling channels just behind forming surface provides efficient cooling for faster production.

Minimised useless volume for faster vacuum. This provides



**-3 ~ -10%**

# FORMING STATION

- Forming cavities are manufactured from Aluminium Alloy 7075 T6
- Polished forming surface with invisible vacuum holes
- Special design centering is used for external cutting precision.



Hard Anodised and Teflon Coated forming surfaces for long lasting life and ease of shaping during forming process.



The fixing bolts under the cliché (hold with magnet) facilitate change of inserts and saves down time during height changes. No need to take the mould out of the machine.



# FORMING STATION



**HYTAC Plug Assist shaped in the form of product makes sheet distribution even throughout the product surface.**

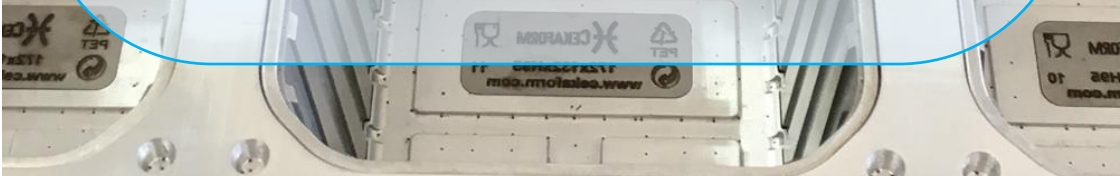


**Motorised plug assists provides stretching control to the operator thus even material distribution is achieved easily.**

**Plug assists are polished to provide scratch free product surface and easy stretching.**



**Superb rim surfaces thanks to cooled clamping frame**



# PUNCHING STATION

Strong and  
Durable punching  
station to perform  
for a long time.

Engineering metals are used  
for long lasting service life.

Metal : Powder Metal  
Hardness  $\geq 58$  HRC

TiN Coating

Efficient, single point, scrap  
collecting / suction exit.

Can be easily adapted to  
height changes thanks to  
patented centering  
system.



Punching force  
is decreased  
thanks to  
specially designed cutting tips.

# PUNCHING STATION

“mm” is not  
enough for our  
precision we play  
with “ $\mu\text{m}$ ”



More than  
**7.000.000 cycles**  
and still running.

Cutting Edges  
still sharp



# CUTTING STATION

Cutting Anvil Metal: DIN 1.2379

Hardness  $\geq 55$  HRC

Top & Bottom surfaces are equal parallel.

Can be used several times by regrinding.



Self – aligning  
(floating - swimming)  
Steel rule cutters  
are arranged on metal  
templates .  
World's famous brands

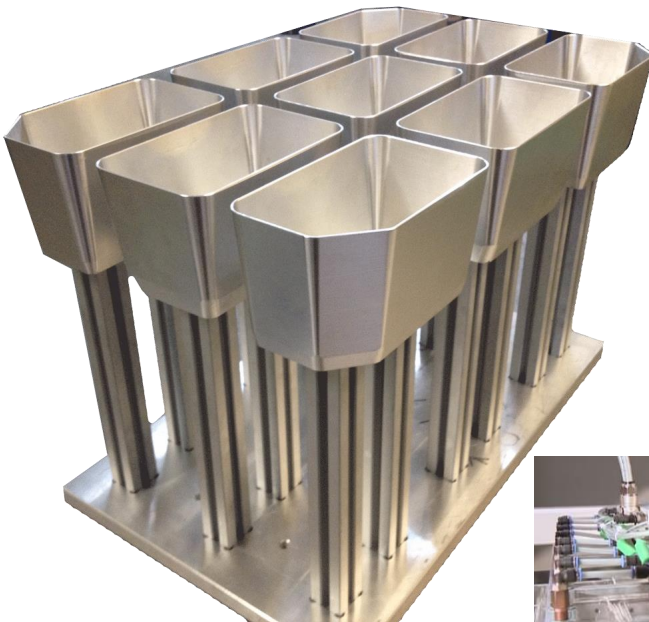
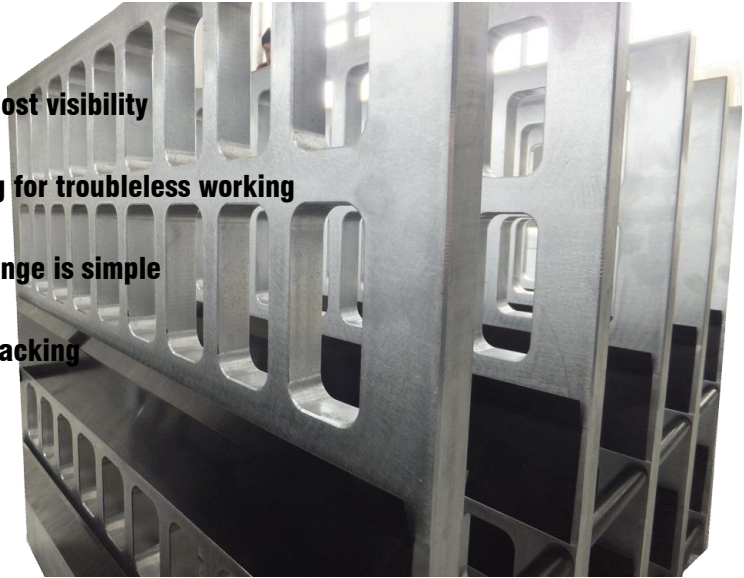


are used



# STACKING STATION

- **Light – weight**
- **Perforation for utmost visibility**
- **Two levels stacking for troubleless working**
- **Stacking sheet change is simple**
- **A – B, A – B – C Stacking**
- **Robot Stacker**



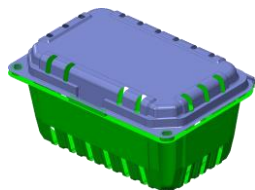
**Product  
fitting  
pushers  
made of  
Aluminium**





# PRODUCT SAMPLES

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**Material** : PET  
**Cavity** : 3 x 2  
**Cycle** :  $\geq 35$  cycle / minute  
**Punches** Body : 6 x 12 mm .... 18 pcs  
Lid : 6 x 12 mm .... 16 pcs

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**Material** : PET  
**Cavity** : 5 x 2  
**Cycle** :  $\geq 40$  cycle / minute  
**Punches** Body : 4 x 12 mm .... 12 pcs  
Lid : 4 x 8 mm .... 12 pcs

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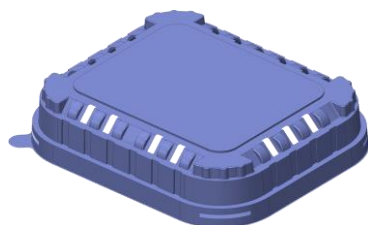
**Material** : PET  
**Cavity** : 5 x 3  
**Cycle** :  $\geq 45$  cycle / minute  
**Punches** : 4 x 8 mm .... 14 pcs

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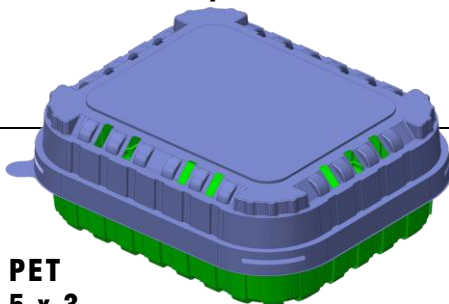


**Material** : PET  
**Cavity** : 5 x 3  
**Cycle** : 60 cycle / minute  
**Punches** :  $\varnothing$  8 mm .... 4 pcs

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**Material** : PET  
**Cavity** : 5 x 3  
**Cycle** :  $\geq 40$  cycle / minute  
**Punches** : 4x10mm .... 14 pcs



# PRODUCT SAMPLES

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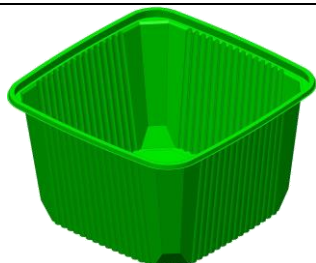
**Material** : PET  
**Cavity** : 3 x 2  
**Cycle** :  $\geq 35$  cycle / minute

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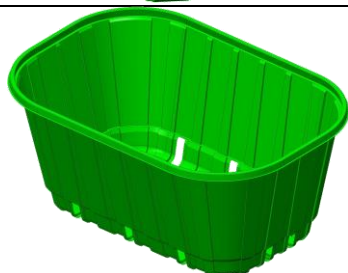
**Material** : PET  
**Cavity** : 5 x 2  
**Cycle** :  $\geq 40$  cycle / minute

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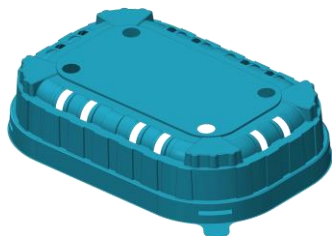
**Material** : PP  
**Cavity** : 5 x 3  
**Cycle** :  $\geq 35$  cycle / minute

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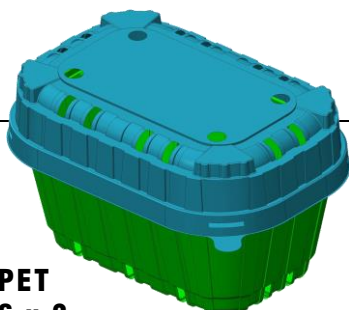


**Material** : PET  
**Cavity** : 6 x 3  
**Cycle** : 40 cycle / minute  
**Punches** : 4x10mm .... 10 pcs

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**Material** : PET  
**Cavity** : 6 x 3  
**Cycle** : 40 cycle / minute  
**Punches** : 4x10mm .... 12 pcs  
 $\varnothing 8$ mm ..... 4 pcs

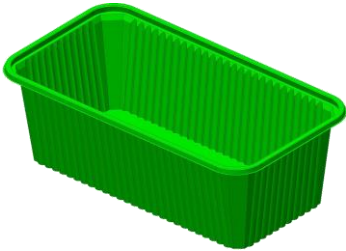


# PRODUCT SAMPLES

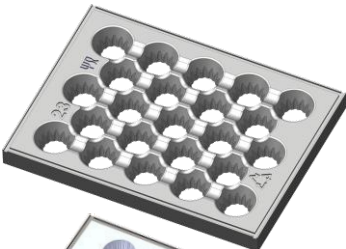
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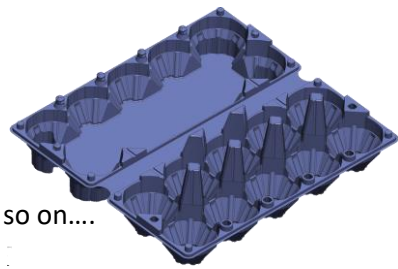
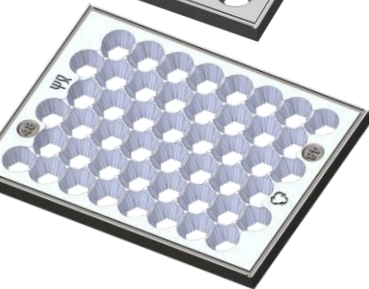
**Material** : PET  
**Cavity** : 6 x 4  
**Cycle** :  $\geq 33$  cycle / minute  
**Punch** :  $\varnothing 26$  mm



**Material** : PP  
**Cavity** : 4 x 2  
**Cycle** : 36 cycle / minute



**Material** : PP / PET  
**Size** : 300 x 400mm (30\*40cm)  
**All Calibers**  
30\*50, 40\*60, etc.  
**Cycle** : 56 cycle / minute



And so on....

**We make moulds for**

**thermoforming machines of:**

**KIEFEL  
TECHNOLOGIES**

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**And other 3 and 4 Station Machines**

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